

# Work Order ID 60109



Page 1

June 24, 2010 11:42:30 AM

Item ID: D350-604-041  
 Revision ID:  
 Item Name: Rear Locker Extender

Accept



Setup Start  
 Stop



Start Date: 6/24/10 Start Qty: 1.00  
 Required Date: 8/06/10 Req'd Qty: 1.00



Cust Item ID:  
 Customer:

Reference:

Run Start  
 Stop



Approvals: Process Plan: CZ Date: 10/6/24 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100  
 DOCUMENT CONTROL  
 DC  
 Document Control

0.00  
 0.00

Memo  
 Photocopy bluefile and create labels per PPP D350-604-041 CHG002

*8/10/08/09*  
*for MF 10/08/09*

110  
 PURCHASING  
 Purchasing  
 Purchasing

0.00  
 0.00

Memo  
 Issue P/O: 12157  
 Description: D350-604-041 Rear locker extender.  
 Supplier: Delastek.  
 Certification of Conformity and process sheet from Delastek is required.  
 4 x 2600-6 Camlock stud - Ship to Delastek B m114654

CZ 10/6/24 ①

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60109



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June 24, 2010 11:42:30 AM

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 6/24/10 Start Qty: 1.00



Cust Item ID:

Required Date: 8/06/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Receive & Inspect for Damage & Mat'l Certs Packaging	0.00				①			
Packaging	Memo	0.00							
Packaging	Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.								
130 	QC5- Inspect part completeness to step on W/O	0.00				②			
QC	Memo	0.00							
Quality Control	Check hole locations to template. DT 8824 Check process sheet and audit.								
140 	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

MF 10-8-7

8/26/09

10/8/9

sf

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60109**

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June 24, 2010 11:42:30 AM

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 6/24/10 Start Qty: 1.00



Cust Item ID:

Required Date: 8/06/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC4- 100% Inspect kits for completeness	0.00							
QC Quality Control	Memo	0.00	510608109			FL			
160 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-604-041 □ Location: <u>50</u> □ PPP Rev: <u>5</u>								
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/8/98

10/08/10  
MF  
10-8-9

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 24, 2010 11:42:29 AM

Page 1

Work Order ID: 60109

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender





Start Date: 6/24/10

Required Date: 8/06/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01 Reformat KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6  Camlock Stud		Purchased	No			100	Each	78.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST381		78							
				114238		4							
				114355		24							
				114654		50							
D2268  Decal		Manufactured	No			150	Each	10.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST010		10							
				57535		10							
D2269  Decal		Manufactured	No			120	Each	12.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST010		12							
				55728		2							
				57536		10							
D350-604-041P  Rear Locker Extender		Purchased	No			140	Each	0.0000	1	1			

4 08/10/6/25

10/8/9 SF

1 10/8/9 SF

1 10/8/9 SF 60109

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

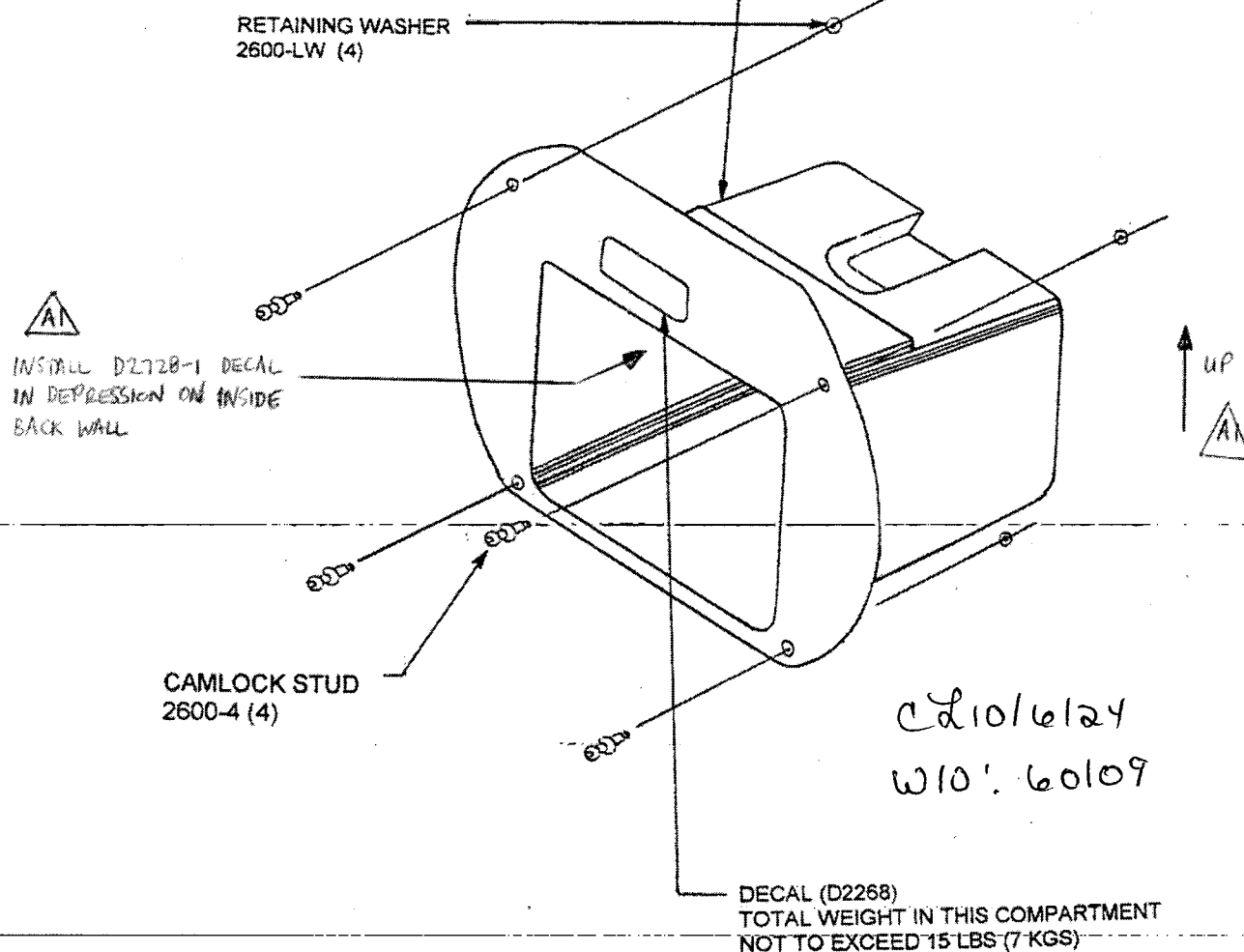
**NOTE:** Date & initial all entries





DESIGN BW		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D350-604-041 REV. A SHEET 1 OF 1	
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY SCALE NTS			
A	02.04.01	NEW ISSUE			
A1	02.04.23	ADD D2728-1 DECAL + ORIENTATION NOTE			
REAR LOCKER EXTENDER (D2273)					

RELEASED  
02.04.03



### D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE A1

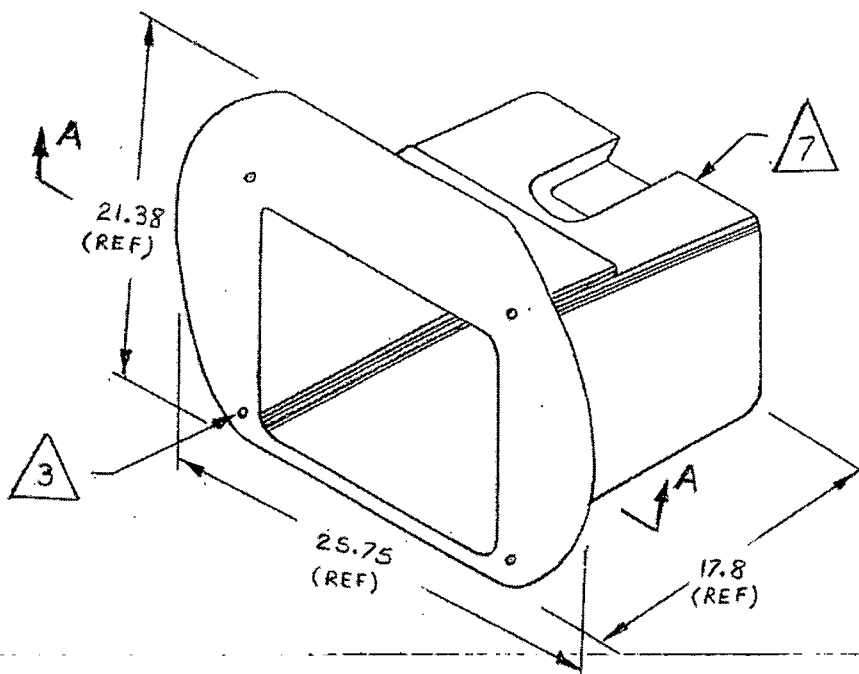
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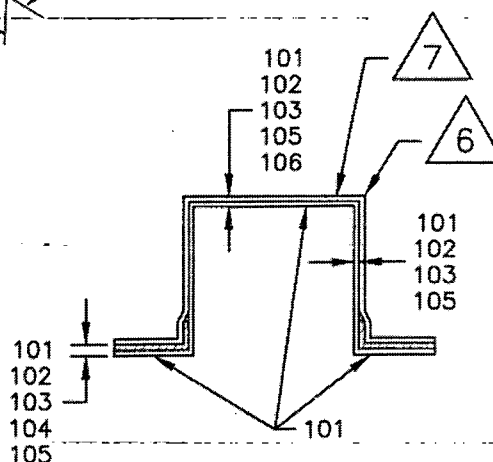
DESIGN	JB	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	DRAWING NO. D2273 REV. D SHEET 1 OF 1
DATE	02.04.01	TITLE	350 REAR LOCKER EXTENDER SCALE NTS
B	96.05.27	RE-DRAWN	
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING	
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH	

RELEASED  
02.04.03



**NOTES:**

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO  $\phi 0.257$  (4 PLACES).
- 4) MATERIALS:  
RESIN: DERAKANE 470-36/411/510A40  
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS  
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:  
101-WHITE GLOSS GELCOAT # GEL 944W005.  
102-9oz ALL OVER.  
103-18oz ALL OVER.  
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.  
105-9oz ALL OVER.  
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.



SECTION A-A

W/D: 60109

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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-604 REV. B

REF TCCA STC: SH90-4

REF FAA STC: SR00463NY

## PURPOSE:

The 2600-4 Camloc Studs may be too short for some installations.

## CHANGE:

The qty (4) 2600-4 Camloc Studs are replaced with longer 2600-6 Camloc Studs. It is acceptable to install either 2600-4 or 2600-6 Camloc Studs. The parts list of D350-604 Rev. B is amended as follows:

QTY	PART NUMBER	DESCRIPTION
-041		
X	D350-604-041	REAR CARGO COMPARTMENT EXTENDER ASS'Y

## IS:

4	2600-6	CAMLOC STUD
---	--------	-------------

## WAS:

4	2600-4	CAMLOC STUD
---	--------	-------------

60109

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.07.01

CERT. NO.: SH90-4

ISSUE NO.: 3

A	NEW ISSUE, NCR 09-046	CP	09.07.01
REV:	DESCRIPTION	BY	DATE
DESIGN	<i>99</i>	DART AEROSPACE LTD	
DRAWN	<i>99</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>NIA</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>NIA</i>	DSI 9470	SHEET 1 OF 1
APPROVED	<i>NIA</i>	TITLE	SCALE
DE APPR.	<i>NIA</i>	CAMLOC CHANGE	NTS
DATE	09.07.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	34096
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #
05/08/2010	28/06/2010	14583	Chantal Lavoie	PO12157		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description		
1	0	1	DKC134-0003	LINE 1 Rear Locker Extender D350-604-041P B60107 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  No. série                      No. lot B60107                          26292		
1	0	1	DKC134-0003	LINE 2 Rear Locker Extender D350-604-041P B60108 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  No. série                      No. lot B60108                          27332		
1	0	1	DKC134-0003	LINE 3 Rear Locker Extender D350-604-041P B60109 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  No. série                      No. lot B60109.                        27331		

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Continued on next page

☒ Cust.    ☐ Adm.    ☐ Quality    ☐ Ship.

Accepted by:

Quality department

AQ-357





Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

<b>Invoice #</b>	34096
<b>Customer #</b>	DART US

**Telephone: (819) 533-5788**  
**Warehouse: MAIN**

**Bill to:**

**DART AEROSPACE LTD**  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Ship to:**

**DART AEROSPACE LTD**  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Telephone:** 613-632-5200  
**Contact:** Linda Lacelle

<b>Ship via</b>		<b>F.O.B.</b>		<b>Terms</b>		<b>Salesperson</b>	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
<b>Ship date</b>	<b>Order Date</b>	<b>Our PO #</b>	<b>Order by</b>		<b>Your PO #</b>		<b>GST/PST #</b>
05/08/2010	28/06/2010	14583	Chantal Lavoie		PO12157		
<b>Order Qty</b>	<b>B.O. Qty</b>	<b>Current Ship.</b>	<b>Item #</b>	<b>Item Description</b>			
1	0	1	DKC134-0003	LINE 4 Rear Locker Extender D350-604-041P B60110 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> B60110			
				<u>No. lot</u> 27333			

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

Accepted by:

Quality department

AO-357

☒ Cust.      ☐ Adm.      ☐ Quality      ☐ Ship.

Date: Lundi, 2010-06-28 10:36:20  
Utilisateur: marc dubé

## Feuille de Procédé

Client : DART US DART AEROSPACE LTD  
Numéro Job : 27331  
Numéro Soumission : 3482  
Numéro B.A. :  
Cette fois : 2010-06-28 No. B.V. :  
Prsht Rev. : NC  
Prem. fois : - - Type :  
Job précédente : 26292Nom Dessin : REAR LOCKER EXTENDER  
Numéro Article : DKC134-0003  
Numéro Dessin : D350-604-041 & D2273  
Projet Numéro : DK-362  
Révision dessin : A & D  
Matériel : Derakane 470-36/411/510  
Date Dûe : 2010-07-05 Qté: 1 Udm: UNITE

B 60109

Écrit par :  
Vérifié & Approuvé par :  
Commentaires : N° de pièce Laminée Dart Aerospace: D2273  
N° de pièce Assemblage Dart Aerospace: D350-604-041Process Sheet Rév.: 00 Création du premier à partir de la révision  
12 du planning De Delastek Composites

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentair Qty.: 0.02 UNITE(s)/Unit Total: 0.02 UNITE(s)

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

Nettoyer le moule à l'aide d'un chiffon humide et sécher à l'air. Selon I.F. # DKC134-0003-5.

Note: Afin que le frekote agisse pleinement, le moule doit être libre de toute  
contamination, enlever tout contaminants à l'aide de Frekote PMC, PMC  
Plus ou tout autre solvant efficace. Il est permis d'utiliser un abrasif (Doux)  
afin d'enlever tout accumulation de résine sur le moule.Appliquer 2 couches de Frekote 44-NC à l'aide du chiffon propre en laissant sécher pendant 15 minutes  
entre les couches. Le séchage de la dernière couche doit être de 3 heures à température de la pièce avant  
d'appliquer le Gel Coat.

Date: Sceau:

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.580 UNITE(s)/Unit Total: 1.580 UNITE(s)

Gel Coat Blanc N° Gel 944W005

N° de Lot: 1-27406-1

4.0 AMB0286

Catalyst N° DDM-9








Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

Date: Lundi, -2010-06-28 10:36:20  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: REAR LOCKER EXTENDER	
Numéro Job: 27331		Numéro Article: DKC134-0003	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
5.0	AC0747	Acetone	
Commentair Qty.: 0.200 KILOGRAMME(s)/Unit		Total : 0.200 KILOGRAMME(s)	
6.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
Faire la préparation du matériel selon I.F. # DKC134-0003-5 :			
Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.			
Date: 12-7-10		Sceau: 	
7.0	GEL COAT	Application du Gel Coat	
			
Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs			
Selon I.F. 134-0003			
À l'aide d'un fusil à gel coat appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DKG 362-010 et laisser sécher pendant un minimum de 2 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.			
Note: Le gel-coat ne doit contenir aucun "airdry", ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.			
Autocontrôle de fabrication. ( Visuel du Gel Coat )			
Date: 12-7-10		Sceau: 	
8.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 1.680 LITRE(s)/Unit		Total : 1.680 LITRE(s)	
Résine (411B7530) 411-350 promo. 75min		N° de Lot: 1-27817-1	
9.0	AMB0286	Catalyst N° DDM-9	
Commentair Qty.: 0.0070 GALLON(s)/Unit		Total : 0.0070 GALLON(s)	
Catalyst N° DDM-9		N° de Lot: 1-22176-1	
10.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Commentair Qty.: 4.6 VERGE(s)/Unit		Total : 4.6 VERGE(s)	
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish		N° de Lot: 1-26697-1	

Date: Lundi, 2010-06-28 10:36:20

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 27331

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

11.0 AMB0213

WR1850 Roving 18oz. x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)  
WR1850 Roving 18oz. x 50" N° de Lot: 1-22302-1

12.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Autocontrôle de fabrication. ( Selon gabarits )

Date: 12/6/10 Sceau: 

13.0 LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon I.F. 134-0003

S'assurer de ne pas trapper d'air entre les rangs

Inscrire les informations suivantes:

Humidité: 49% Température: 19.3°F Heure: ---

Date: 13/07/10 Sceau:  

14.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total : 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min N° de Lot: ---

15.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9 N° de Lot: ---

16.0 FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon I.F.# DKC134-0003-5.

Date: --- Sceau: ---



Date: Lundi, 2010-06-28 10:36:20

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 27331

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

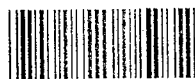
Machine ou Opération:

Description :

17.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F.# DKC134-0003-5.

Faire le démoulage de la pièce en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager .

Autocontrôle de fabrication.( Visuel )

Date:

14-7-10

Sceau:



18.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon I.F.134-0002

Autocontrôle de fabrication.( Visuel et dimensionel selon le dessin )

Date:

14-7-10

Sceau:



19.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.3400 UNITE(s)/Unit Total : 0.3400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-26804-3

20.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-26804-2

21.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon I.G. 0008

Date: 16-07-10

Sceau:



22.0

AAC1607

Camlock Stud 2600-4 (or Monadnock 1126000-4)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: 1-27174-1

Date: Lundi, 2010-06-28 10:36:21

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 27331

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

23.0

AAC0682

Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot: 1-6687-1

24.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Selon I.F. 134-0004

Démasquer la pièce.

Assembler les quatre (4) Camlock Stud N° 2600-4 à l'aide des Lock Washer N° 2600-LW. Selon l'instruction de travail N° I.G.#Pose de stud.

Autocontrôle de l'assemblage ( Visuel )

Date: 3 août 10 Sceau:



25.0

IDENTIFICATION

Identification à encre indélébile



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F. 134-0005

Faire l'identification de la pièce: N° de pièce D350-604-041

N° de Work Order: # 27331

L'identification doit être vers l'extérieur.

AUG 03 2010

Date: Sceau:



26.0

INSP. FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 3-8-10 Sceau:



27.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage de la pièce dans le contenant approprié.

Date: Lundi, -2010-06-28 10:36:21

Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 27331

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Date: 03-08-10 Sceau:

